

Date: Monday, 9/10/2007 1:18:54 PM
 User: Kim Johnston

Process Sheet

Split 2

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 34474	
Estimate Number : 12578	
P.O. Number : <u>N/A</u>	Part Number : D3560041
This Issue : 9/10/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3560 UNDER REVIEW <u>EC</u>
Prsht Rev. : <u>NC</u>	Project Number : <u>N/A</u>
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : <u>B/C</u>
Previous Run : 33844	Material : <u>N/A</u>
Written By : _____	Due Date : 9/17/2007
Checked & Approved By : _____	Qty: <u>5</u> Um: <u>12</u> Each
Comment : Est Rev:A New Issue 07.05.24 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar 50" x 5.0"
-----	--------------------	------------------------



Comment: Qty.: 1.4648 f(s)/Unit Total : 17.5770 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: M105646mk 07/09/20

(12)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks 16.750" long

mk 07/09/20

(12)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

P10SL 07/09/21

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SL 07/09/21

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SL 07-09-21 (12)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34474

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

PLATE

334260

07-10-10

5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

07-10-10

5

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-10-10

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-10

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-10-10

5

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

07-10-11

5

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34474

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

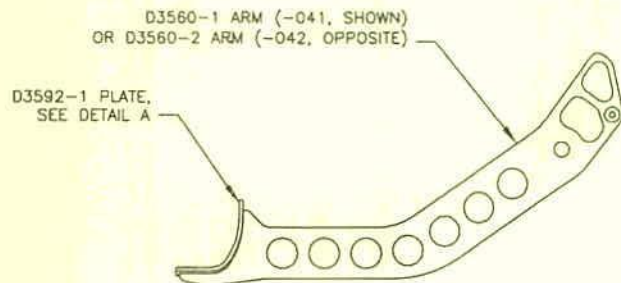
Comment: FINAL INSPECTION/W/O RELEASE

D 09/10/12

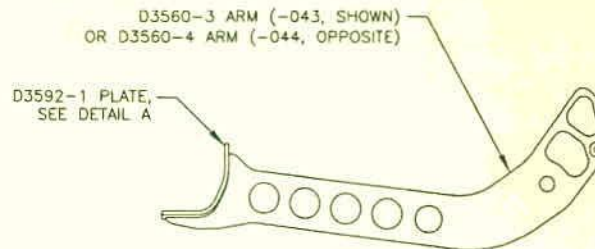
Job Completion



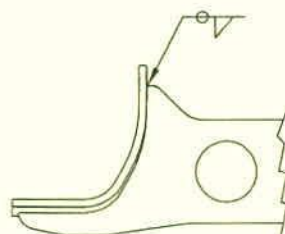
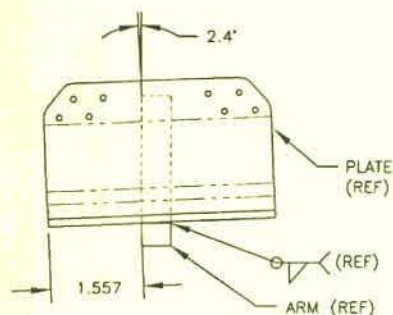
U 09.10.12



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

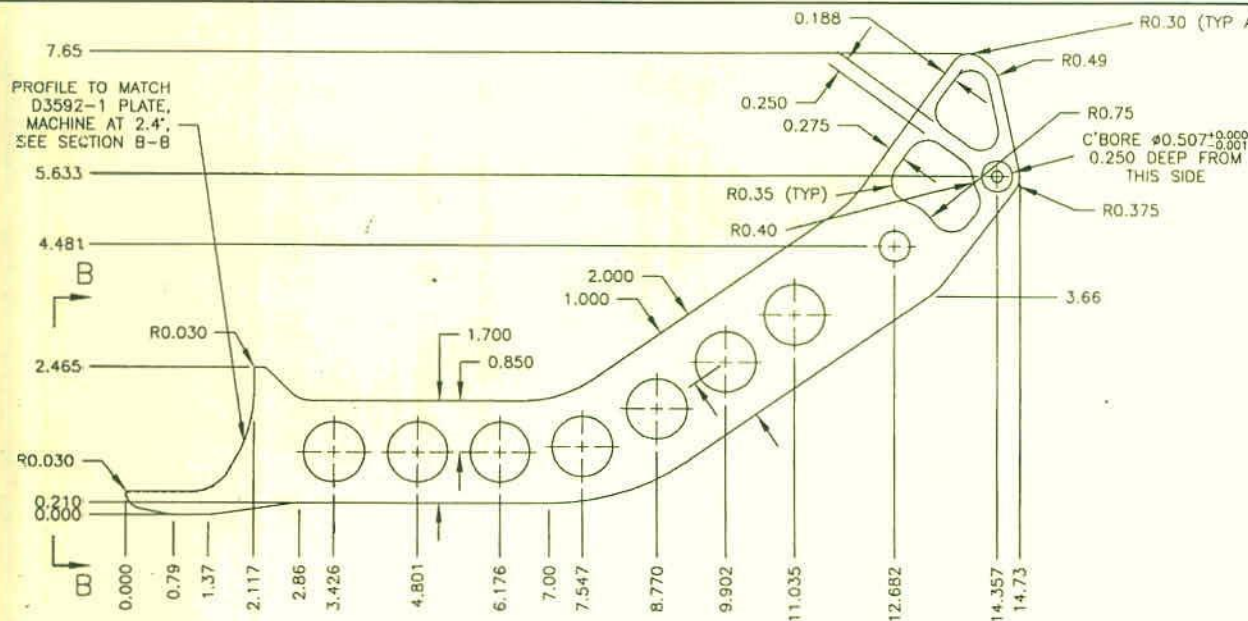
RELEASED
07.06.19

C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	qf	DRAWN BY qf
CHECKED	th	APPROVED
DATE	07.06.19	TITLE
		ARM WELDMENT
		DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
		DRAWING NO. D3560
		REV. C
		SHEET 1 OF 3
		SCALE 1:4

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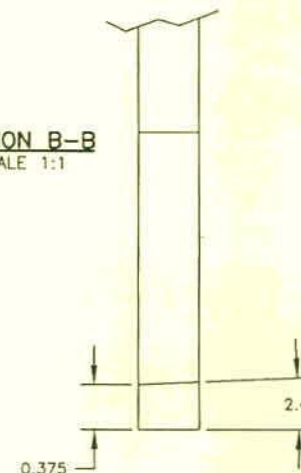
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WORK ORDER
NO. 34474



D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

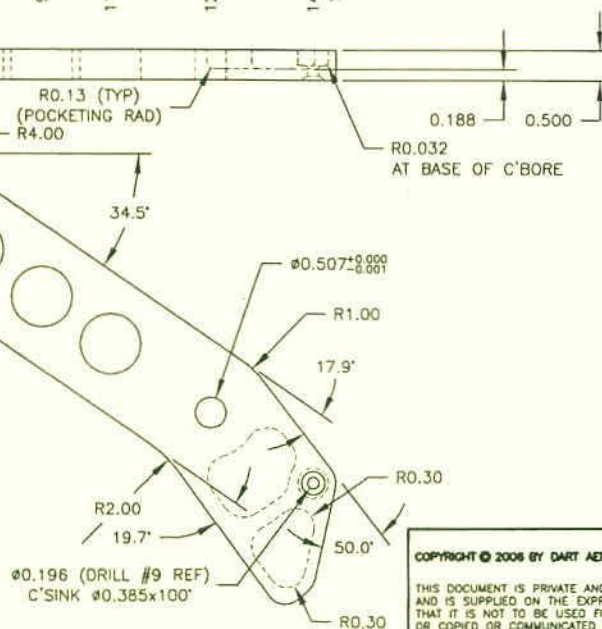
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC.
M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION B-B
SCALE 1:1



RELEASED
07.06.29

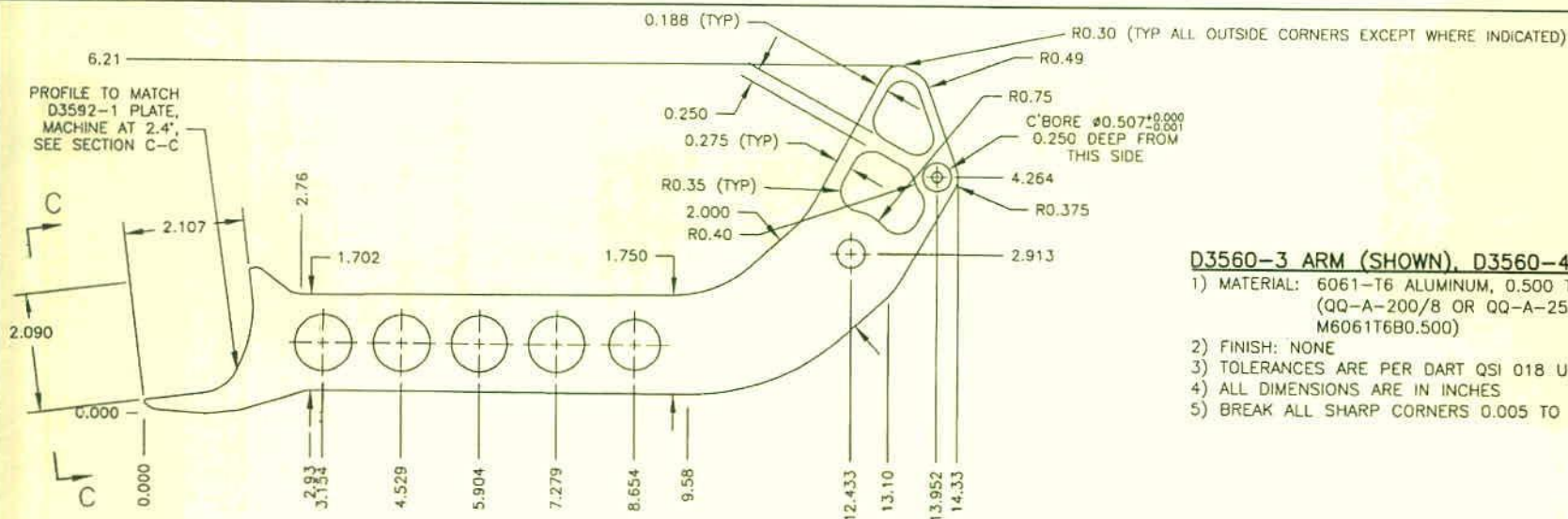
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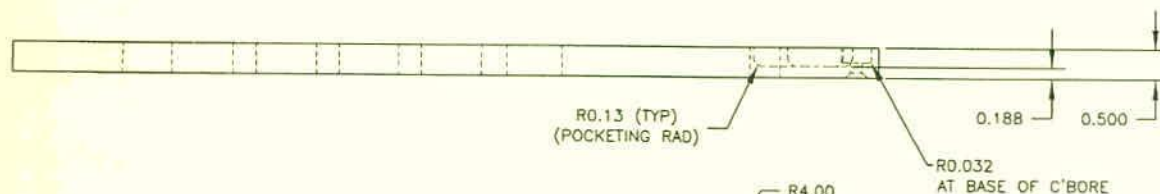
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DESIGN	90	DRAWN BY	90	DART	DART AEROSPACE LTD. WINDERMERE, ONTARIO, CANADA
CHECKED	90	APPROVED	90	DRAWING NO.	D3560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 2 OF 3
				SCALE	1:2

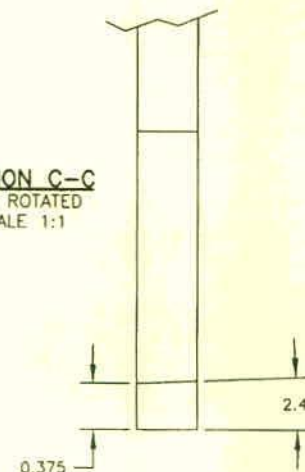


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

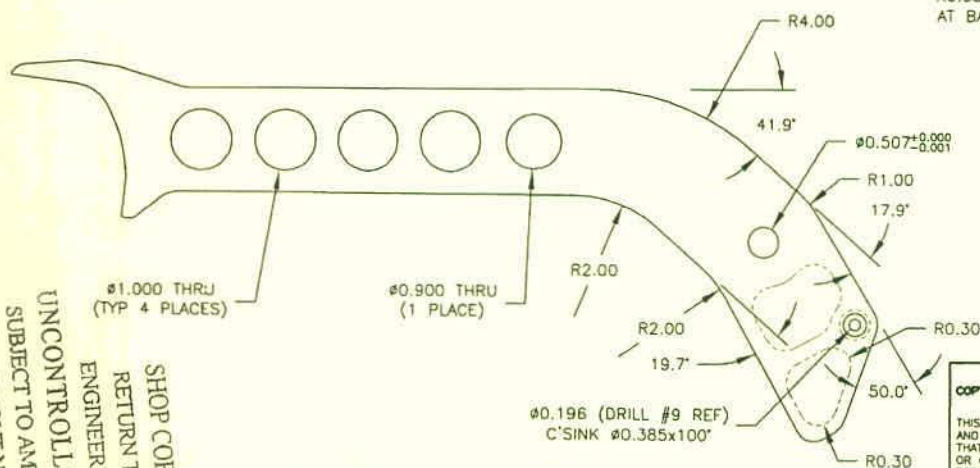
- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



RELEASED
07.06.29



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CHECKED	40	APPROVED	40	DRAWING NO.	03560
DATE	07.06.19	TITLE	ARM WELDMENT	REV. C	SHEET 3 OF 3
				SCALE	1:2

NO. 34474

WORK ORDER

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